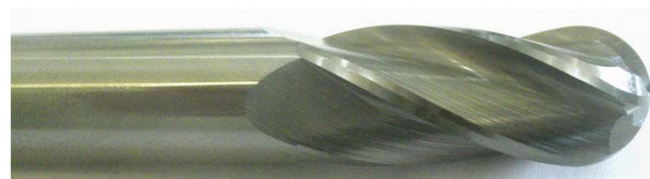
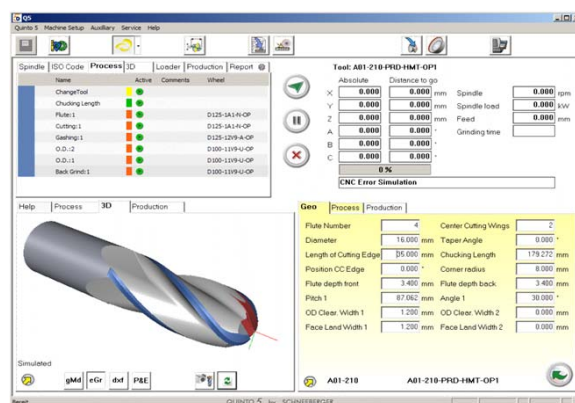
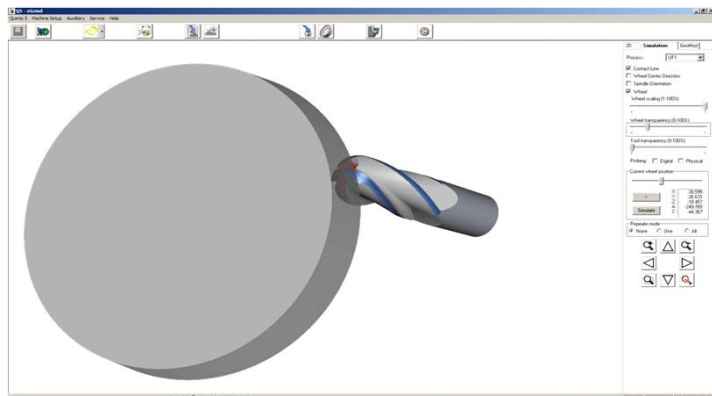


Ballnose Endmill Ø16 Z4 R8

A01-100

The usage of highly efficient hybrid wheels allow to the flutes within reasonable times



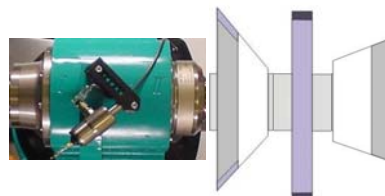
1. Cycletime for Production

Workpiece: Ø 16 mm, Z 4, Length of cutting edge 35 mm, Helix angle 30° Material CARBIDE							
Operations	Probe	Flute 1	Cutting	Gashing	O.D.2	O.D.1	Backgrind
Feed [mm/Min]	2000	80	120	100	150	300	150
Power [kW]		3	2	2	1	2	1
Cutting feed [m/s]		18	18	22	22	22	22
Used wheels							
Grinding time [s]	15	155	46	58	232	128	27
Total cycle time	11 Min 1						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64
2	12V9 Ø125 D64
3	11V9 Ø100 D64



2 1 3

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEM DMR

Control: Fanuc 31i

Accessories:

Responsible engineer: OP. 11.6.10

Coolant: Synthetic Oil, pressure 10 bar

Software: Quinto 5

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, China